

16/07/25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐	
Design ☐	☐ Operator	Bending ☐		Set-up ☐		Folio/Program ☐	Positioned Wrong ☐
Doc/Data ☐	☐ Offset/Setup	Centre Not Concentric ☐		BOM/Route ☐		Grain ☐	Outside Dimensions ☐
Equip/Tooling ☐	☐ Supplier	Cracks ☐		Broken/Damage/Defect ☐		Weld ☐	Over/Under tolerance ☐
Handling/Pre ☐	☐ Training	Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐		Wrong Stock Pulled ☐	Part Incorrect ☐
Material ☐	☐ Use for Testing	Cuffs ☐		Contamination ☐		Out of Sequence ☐	Part Lost/Missing ☐
Internal Transport ☐	☐ Poor Information	Crushing ☐		Countersink ☐		Off-set ☐	Part Moved ☐
Tribal Knowledge ☐	☐ Rushing	Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐	Drawing ☐
LOA ☐	☐ Product Improvement	Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐	Finish ☐
Substation ☐	☐ Process Improvement	Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐	Misread ☐
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

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Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

Work Order ID 148808

July 08, 2016 11:35:00 AM

148808

Page 3

Item ID: PB67-43001-97

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clevis

Start Date: 7/8/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/3/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

DAS
21
9-89

JUL 26 2016

DAS
21
9-89

JUL 26 2016

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 148808

148808

Parent Item: PB67-43001-97

PR67-43001-97

Parent Item Name: Clevis

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP B05.10.14Removed powder coat & added step 9KJ/EC
IPP Rev:B Now on Doosan Lathe 08-06-25 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.000		Purchased		No		100	f	24.0000	0.1833	0.1833			

M6061T6R1 000

ROUND BAR 1.00"

******LocationLoc QtyLoc Code

MAT012

24

m134553

12

m134776

12

1.4 ⁴

DAS

45

9-89

2016-7-23

DQA: _____ Date: _____



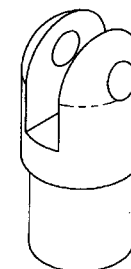
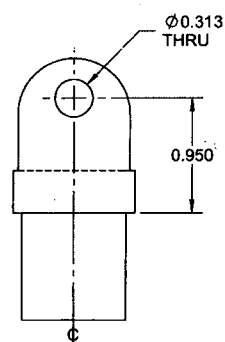
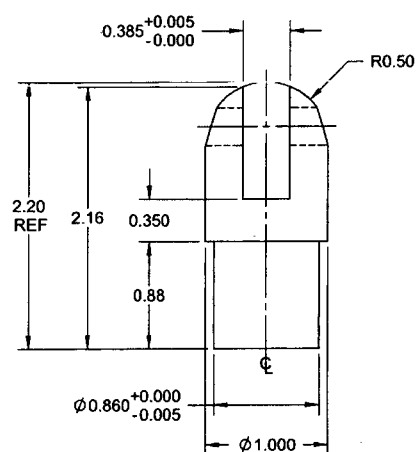
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				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : _____			



B67-43001-97 CLEVIS

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

RELEASED
2009-09-24

574 7/12/16 148808

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 30 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.24
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-97	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.	N/A	CLEVIS	NTS	
DATE	09.02.24	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

